

Work Order ID 111628

Wednesday, January 15, 2014 3:14:06 PM

111628

Ship today Page 1

Item ID: D315-670-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 1/15/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/15/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2432	Rev F3

MJ 14-01-08

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D315-670-011 CHG001

DAS 6 14-1-15

1

150

Pick Kit

0.00

150

Packaging

Memo

0.00

Packaging

DAS 33 14-01-15
9-89

1

160

QC4- 100% Inspect kits for completeness

0.00

160

QC

Memo

0.00

Quality Control

DAS 6 14-1-15
9-89

1

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Item ID: D315-670-011

Accept

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Item Name: Bearpaw

Start Date: 1/15/2014 Start Qty: 1.00 *1*

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location:	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21 - Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

DAS
6
9-89

MLJ 14-01-15

MR
14-01-15

Picklist Print

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Page 1

Work Order ID: 111628

Parent Item: D315-670-011

Parent Item Name: Bearpaw

Start Date: 1/15/2014

Required Date: 1/15/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-03 JLM
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC IPP RevG: revise seq
 in route DD 10.01.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A Bolt		Purchased	No			150	Each	729.0000	12	12	DAS 33 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st357		29							
				M127432		29				127432			DAS 31 9-89
				ST515		700							
				M127817		700							
D2182B Seal (SP-5 Foot)		Manufactured	No			150	f	255.4200	25	3	DAS 33 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST412		255.42							
				101827		1							
				108914		254.42				108914			DAS 37 9-89
D2274 Radius Block		Manufactured	No			150	Each	747.0000	12	12	DAS 33 9-89		14-01-15
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		12							
				86855		12							
				ST007		8							
				65047		8							
				ST008		727							
				108466		30				108466			DAS 31 9-89
				109534		397							
				110264		300							

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Work Order ID: 111628

Parent Item: D315-670-011

Parent Item Name: Bearpaw

D2432
Bearpaw 19" X 24"

Manufactured No

150 Each

2.0000

2

DAS

33

9-89

Location

Loc Qty

ST269

2

69653

1

99766

1

Loc Code

DAS
31
9-89

1769653
1799766
6 6

D2438
Clamp

Manufactured No

150 Each

40.0000

DAS

33

9-89

Location

Loc Qty

FG

4

87532

4

ST456

36

108855

36

Loc Code

DAS
31
9-89

108855
12 12

D2529
Washer

Manufactured No

150 Each

271.0000

DAS

33

9-89

Location

Loc Qty

ST011

271

108881

200

109580

71

Loc Code

DAS
31
9-89

109580
12 12

MS2104214
Locknut

Purchased No

150 Each

4,784.0000

DAS

33

9-89

Location

Loc Qty

GA

74

m126333

74

ST509

4000

m127255

2000

m127813

2000

ST518

710

m127376

710

Loc Code

DAS
31
9-89

127376

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Work Order ID: 111628

Parent Item: D315-670-011

Parent Item Name: Bearpaw

NASH49D0463J
WASHER

Purchased

No

150

Each

Start Date: 1/15/2014

Required Date: 1/15/2014

Start Qty: 1.00

Required Qty: 1.00

7,525.0000

24

24

DAS
33

14-01-15

Location

Loc Qty

ST294

3125

M127693

3125

ST510a

4400

M127813

1400

M127904

3000

Loc Code

9-89

DAS
31
9-89

127693

DAS
6
9-89

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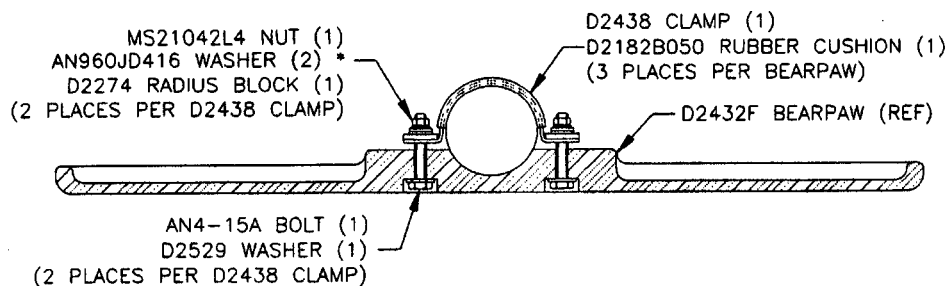
Shop Packet Print

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REFERENCE ONLY

DAS
6
9-89

REFERENCE ONLY



* Additional AN960JD416 washers may be added to ensure 2-4 threads remaining on bolt.

Figure 3 - Bearpaw Section - Clamp Installation

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D315-670-011 Bearpaw	12.5 lb 5.67 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	146.1 in 3.71 m	1826.3 in-lb 21.03 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D315-670-011	BEARPAW KIT
6	D2182B050	Rubber Cushion
12	D2274	Radius Block
2	D2432F	Bearpaw
6	D2438	Clamp
12	D2529	Washer
12	AN4-17A	Bolt
24	AN960JD416	Washers
12	MS21042L4	Nut (or MS21042-4)